

Work Order ID 62674

Wednesday, October 06, 2010 2:55:17 PM

Page 1

Item ID: D2198-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/6/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2198

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2198

304, 663

Dwg Rev: E

Prog Rev: C

2-Deburr if necessary

10-10-14

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-10-14

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/21/14

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2198-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket					
Start Date:	10/6/2010	Start Qty:	6.00			
Required Date:	10/15/2010	Req'd Qty:	6.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00				(12)			
Brake NC	Bend as per dwg D2198								
									SB 10/10/10
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				12			
Quality Control									10/10/10
150 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	POWDER COAT: Start Time: 10:45 Oven Temperature: 400° Finish Time: 11:10								BR 10-10-21
						12			

W/O:		WORK ORDER CHANGES					
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Setup Start

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Stop

Item Name: Bracket

Start Date: 10/6/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 8

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12 0

10/10/21 SF (120)

10/10/22 J
MF
10-10-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, October 06, 2010 2:55:20 PM

Page 1

Work Order ID: 62674

Parent Item: D2198-1

Parent Item Name: Bracket



Start Date: 10/6/2010

Required Date: 10/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd
10.05.03 add powdercoat DD verified :EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	71.3100	0.125	0.789474	1.5		
304/316 Sheet .063													

10-10-14

Location

Loc Qty

Loc Code

MAT

65.47

111323

0

115688

65.47

MAT20

5.84

115440

5.84

115688

(12)

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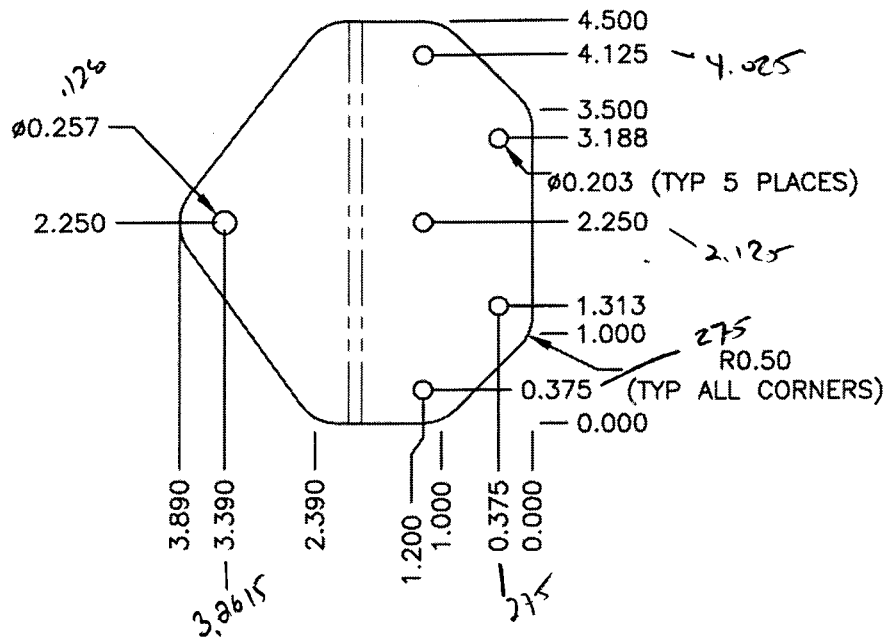
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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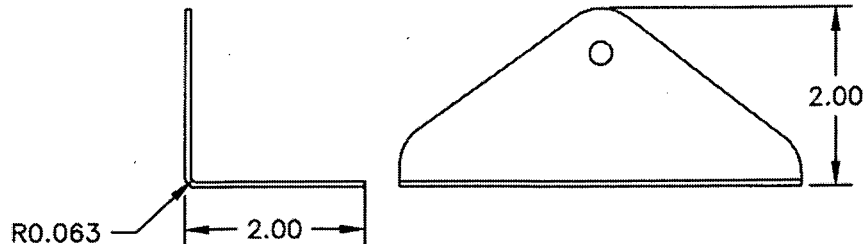
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2198	REV. C SHEET 1 OF 1
DATE 03.05.28		TITLE BRACKET	SCALE 1:2
B	93.10.05	REDESIGN	
C	03.05.28	REDRAW	

RELEASED
03.07.09

SHOP
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBMITTAL
WORKING
NO. *Col. 74*
PS10-1009

**D2198-1
FLAT PATTERN****D2198-1 BRACKET
BEND DETAIL****D2198-1**

- 1) MATERIAL: AISI 304/316 S.S. 0.064" THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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